

Date: Friday, 21/11/2008 8:59:38 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : NUT PLATE ASSEMBLY
Job Number : 43669	
Estimate Number : 11053	
P.O. Number :	Part Number : D2873043
This Issue : 21/11/2008 S.O. No. :	Drawing Number : D2873 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 43176	Material :
Written By :	Due Date : 28/11/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JUD 08/11/21</u>	
Comment : Est A05.09.13 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X01000	6061T6 BAR .375 x 1.00
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Comment: Qty.: 0.3237 f(s)/Unit Total : 6.4743 f(s)

6061T6 BAR

Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)

(M6061T6B0.375x01.000)

Identify for D2873-3

Batch: 7109401107220JUL 08/11/24(23)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 1.000" x 0.375" x 3.700" lng

JUL 08/11/24(23)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA and Dwg D2873

Identify as D2873-3

Dwg Rev A Folio Rev AA20 08/11/25G.A 08/11/24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/11/25G.A 08/11/24(23)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 21/11/2008 8:59:38 AM  
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Drawing Name: NUT PLATE ASSEMBLY

Job Number: 43669

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Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 08/11/25

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2873

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 08/11/26 (23)

counter

S 08/11/26 (23)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 08/11/28

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

96

08-11-28

(23 x)

10.0 MS20426AD46 Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 420.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

6

MS20426AD4-6

Rivet

M105144

EP 08/12/04

11.0 MS21075L5 Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 30.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

3

MS21075L5

Nut Plate

M18136

EP 08/12/04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: NUT PLATE ASSEMBLY

Job Number: 43669

Part Number: D2873043

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-043

*CP* 08/12/04 (23)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S* 08/12/05 (23) *counted*

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *X-tube* Finishing

*m* 08 12 04 (23)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/10 *JW*

Job Completion



*JW* 08.12.08 (23)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <u>L3609</u>
<b>Description:</b> Radius Block		<b>Part Number:</b> <u>D2873-3</u>
<b>Inspection Dwg:</b> D2873	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	✓			
2.000	+/-0.010	2.000	✓			
0.750	+/-0.010	0.749	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	0.249	✓			
1.000	+/-0.010	0.998	✓			
2.000	+/-0.010	1.996	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	Ø0.133	✓			
0.359	+/-0.010	0.359	✓			
Ø0.316	+0.006/-0.001	Ø0.317	✓			
1.000	+/-0.010	1.006	✓			
0.250	+/-0.010	0.249	✓			
0.061	+/-0.010	0.058	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø0.231 x 0.125	✓			

<b>Measured by:</b> <u>B.A</u>	<b>Audited by:</b> <u>[Signature]</u>	<b>Prototype Approval:</b> <u>N/A</u>
<b>Date:</b> <u>08/11/24</u>	<b>Date:</b> <u>08/11/25</u>	<b>Date:</b> <u>N/A</u>

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

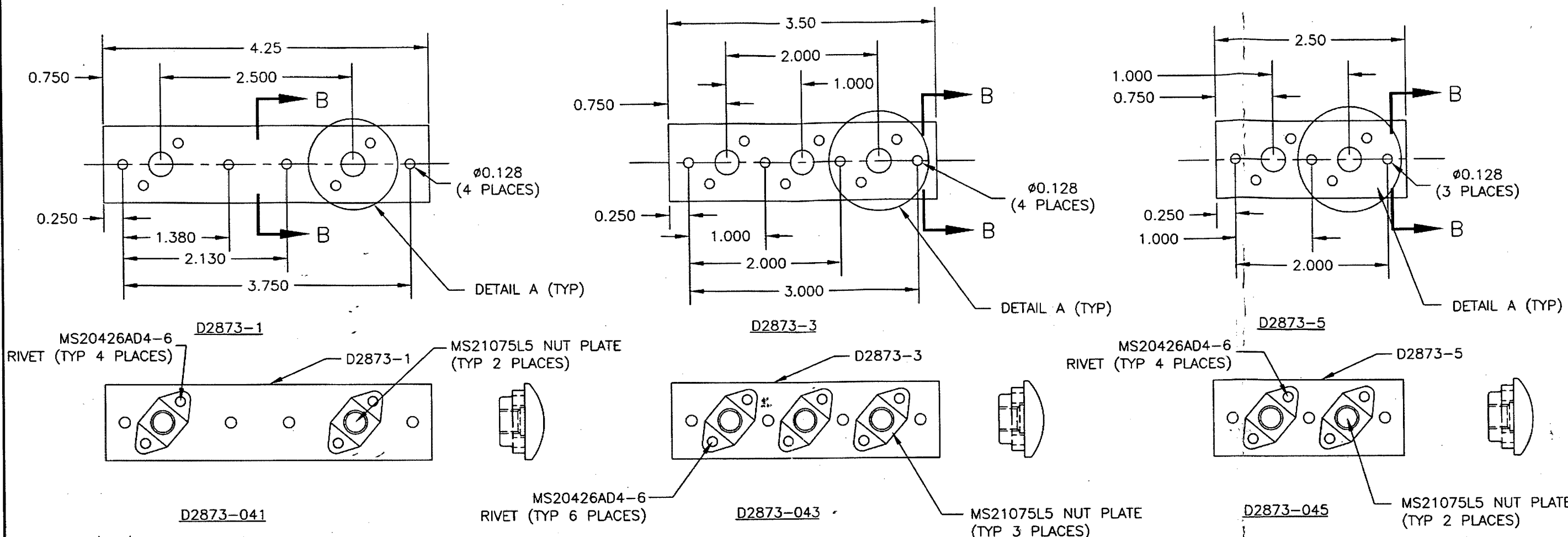
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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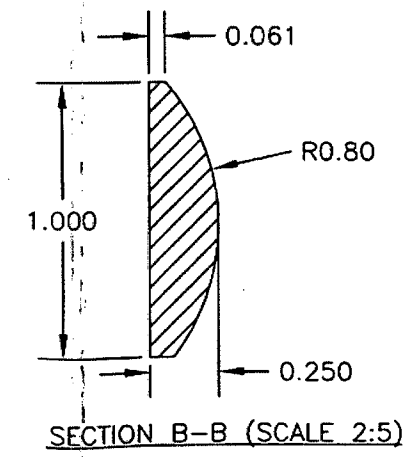
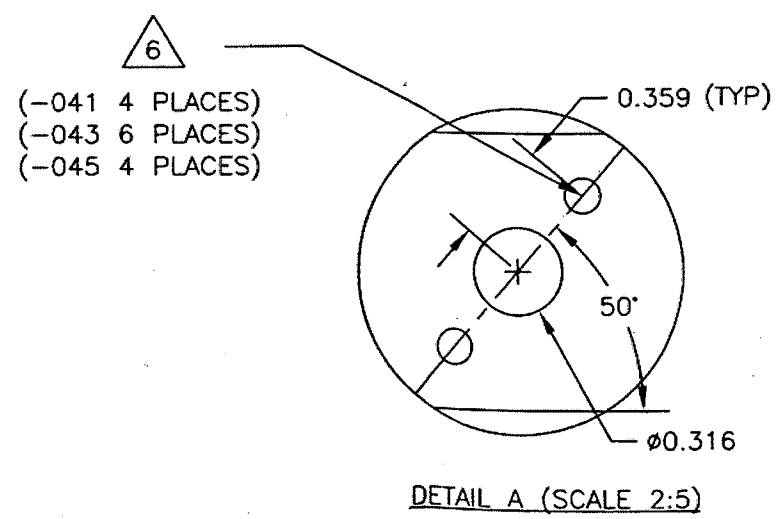


- D2873-1/-3/-5 RADIUS BLOCK**
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
  - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE INCHES
  - 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 6)  $\phi 0.128$  PILOT + C'BORE CURVED SIDE  $\phi 0.230 \times 0.125$  DEEP + C'SINK CURVED SIDE  $\phi 0.225 \times 100'$

- D2873-041/-043/-045 NUT PLATE ASSEMBLY**
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

**D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST**

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873 REV. A SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:5

